

# Work Order ID 54021

November 26, 2009 7:42:57 AM



Item ID: D2888

Accept



Setup Start



Revision ID: A2

Stop



Item Name: Lug

Start Date: 11/27/09 Start Qty: 12.00



Cust Item ID:

Required Date: 12/04/09 Req'd Qty: 12.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2888

Rev A2

100

0.00



Bandsaw

0.00

Jeaspa Bandsaw

Memo

Cut Blanks at 4.200" long  
\*\*\*Grain along 4.200"\*\*\*\*

*Conf 00/11/27*

*137 0*

110

0.00



HAAS 1

0.00

HAAS CNC vertical machine #1

Memo

Machine as per Folio D2888

Folio Rev:

Dwg Rev: A2

2-Deburr

*DTT 09/11/29*

*7*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2888 PAR #: N/A Fault Category: Prod. Eng. Coord NCR: Yes No DQA: ls Date: 09.12.08  
 Resolution: Accepted Disposition: Use as is QA: N/C Closed Date: 01.12.11

NCR: 54021		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.11.30	110	0.375 dim is 0.360, <del>LOW DIM IS 0.425</del> dim is 0.407. RL Program error	<u>GP</u> 09.11.30 per 02.11.30	Acceptable	<u>DJ</u> 09/11/30	<u>S</u> 09/11/30	<u>GP</u> 09.11.30 per 02.11.30	<u>S</u> 01/11/30
				→ Fix Program.	<u>GP</u> 01.12.01			<u>S</u> 01/11/30

NOTE: Date & initial all entries

# Work Order ID 54021

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Item ID: D2888

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*DI 09/11/29*

7

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*88 09/11/30*

7

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

*MO 09/11/30*

17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 54021

November 26, 2009 7:42:58 AM



Item ID: D2888

Accept

Revision ID: A2

Item Name: Lug

Start Date: 11/27/09 Start Qty: 12.00

Required Date: 12/04/09 Req'd Qty: 12.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

M 112148

Memo

START TIME: 1:45

OVEN TEMPERATURE: 320°

FINISH TIME: 2:15

0.00

0.00

BL 09-11-30

(7)

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

=> M. L 09/11/30

(7x) 0

170



Packaging

Packaging

Identify as per dwg & Stock Location: 479

Memo

0.00

0.00

9/11/30 (7x) S

# Work Order ID 54021

November 26, 2009 7:42:58 AM



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Item ID: D2888

Revision ID: A2

Item Name: Lug

Start Date: 11/27/09 Start Qty: 12.00

Required Date: 12/04/09 Req'd Qty: 12.00

Reference:

Approvals: Process Plan: Date:

QC: Date:

Tooling: Date:

SPC (Y/N): Date:



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/01 *[Signature]*

MF 09-12-01

# Picklist Print

November 26, 2009 7:42:56 AM

Page 1

Work Order ID: 54021

Parent Item: D2888RevA2

Parent Item Name: Lug

Comments:

Start Date: 11/27/09

Required Date: 12/04/09

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B2.500X03.50 0		Purchased	No			100	f	18.0675	4.6800			



6061-T6 Bar 2.50 x 3.50



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

18.0675

102838

13.1

110936

1.03

111700

3.9375

~~2.5725~~ 2.5725 JMF 09/11/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DART AEROSPACE LTD		Work Order:	5404
Description: Lug		Part Number:	D2888
Inspection Dwg: D2888	Rev: A2	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

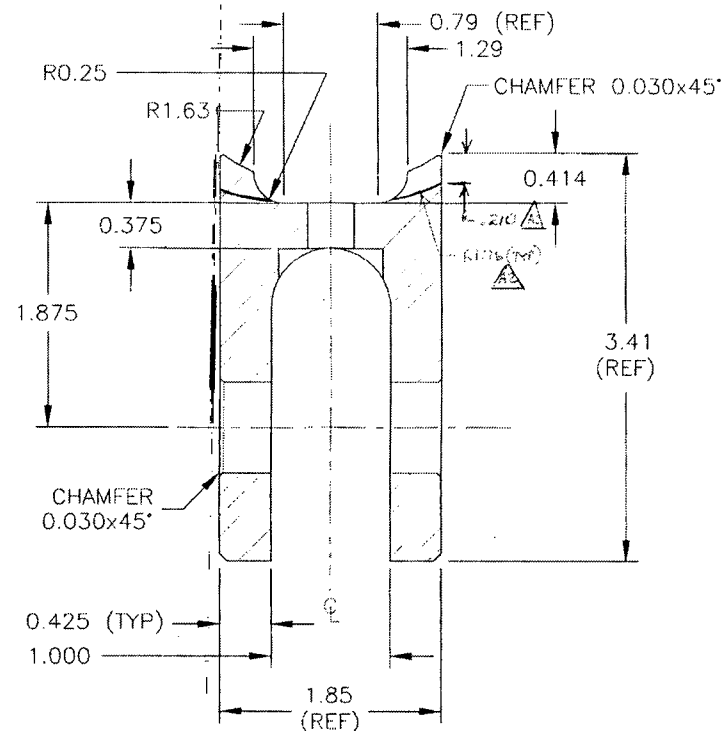
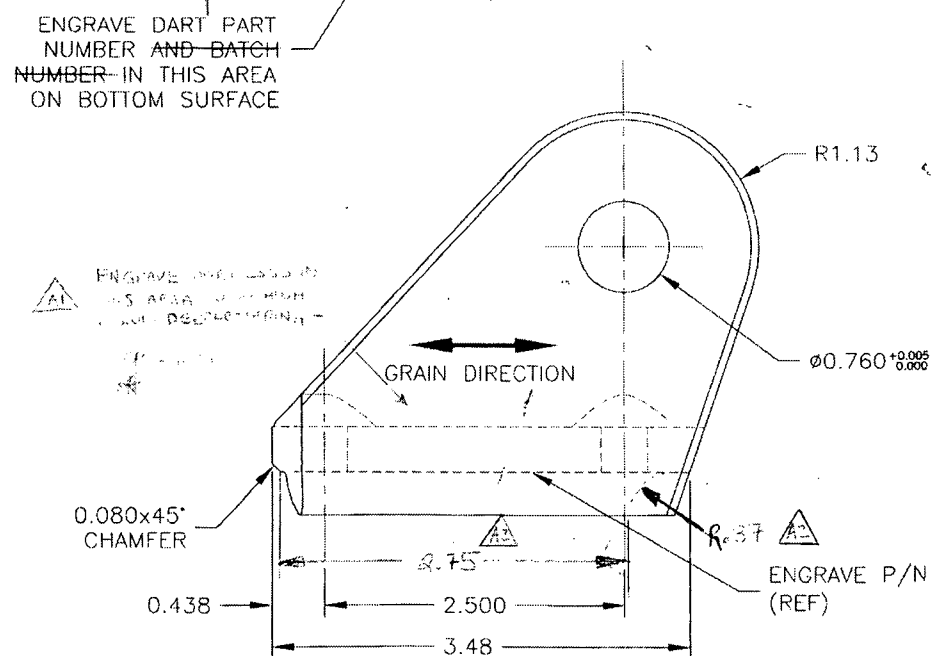
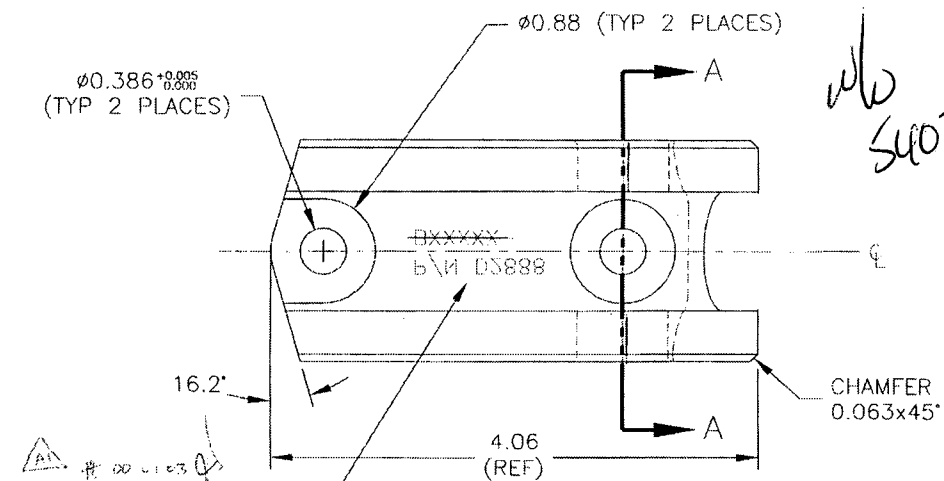
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.386	+0.005/-0.000	0.390	✓			
Ø0.88	+/-0.030	0.876	✓			
0.063 x 45°	+/-0.010	0.053x45°	✓			
4.06	+/-0.030	4.057	✓			
Ø0.760	+0.005/-0.000	0.763	✓			
3.48	+/-0.030	3.48	✓			
2.500	+/-0.010	2.495	✓			
2.75	+/-0.030	2.75	✓			
0.438	+/-0.010	0.431	✓			
0.080 x 45°	+/-0.010	0.076 x 45°	✓			
1.85	+/-0.030	1.85	✓			
1.000	+/-0.010	1.005	✓			
0.425	+/-0.010	0.420	✓			
0.030 x 45°	+/-0.010	0.025 x 45°	✓			
1.875	+/-0.010	1.880	✓			
0.375	+/-0.010	0.372	✓			
R0.25	+/-0.030	0.250	✓			
1.29	+/-0.030	1.287	✓			
0.414	+/-0.010	0.410	✓			
3.41	+/-0.030	3.400	✓			

Measured by:	DJP
Date:	09/11/29

Audited by:	SP
Date:	09/11/29

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.06.04	New Issue	KJ/DD	



SECTION A-A  
SCALE 1:1

RELEASED  
77.07.01 DS

MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
BREAK UNMARKED EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

62	04.04.08	Add Scribe Clearance for NCR 724
A1	10.31	CHANGE FOR V-10

A	99.06.21	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD WILLOWBURGH, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2888
DATE	TITLE	SCALE 1:1
99.06.21	LUG	